



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PB67-43001-73
Job Sheet 160864



Part No: PB67-43001-73

Job Qty: 12 ea

Part Name: 20 Degree Cover Plate



Part Weight: 0 lbs

Status: New

Job Created: 9/30/17

Job Tracking No:

Due Date: 12/1/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 08-06-19 new issue DD verified by:ec IPP rev B 10.09.30 per rev C dwg EC verified by:DD

Ship Via:

50000174
500 3038
Priority: Medium

Start Large Fab 2

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	12 Ea	11/30/17	0.00	0.00	Start up container	
100	Waterjet	12 pcs	11/30/17	0.00	1.02	Waterjet1	
110	QC	12 pcs	11/30/17	0.00	0.00	QC2	
120	QC	12 pcs	11/30/17	0.00	0.00	QC8	
130	Brake NC	12 pcs	11/30/17	0.00	1.36	Brake NC 1	
140	QC	12 pcs	11/30/17	0.00	0.00	QC5	
150	Large Fab	12 pcs	11/30/17	0.00	8.44	Large Fab 2	
170	QC	12 pcs	11/30/17	0.00	0.00	QC10	
180	QC	12 pcs	11/30/17	0.00	0.00	QC5	
190	HandFinish	12 pcs	11/30/17	0.00	0.63	HandFinish1	
200	Powdercoat	12 pcs	12/1/17	0.00	0.67	Powdercoat5	
210	QC	12 pcs	12/1/17	0.00	0.00	QC3	
220	Outsource	12 pcs	12/1/17			TUL001-VC	
230	Packaging	12 pcs	12/1/17	0.00	0.00	Packaging2	
240	QC	12 pcs	12/1/17	0.00	0.00	QC6	
250	Packaging	12 pcs	12/1/17	0.00	0.00	Packaging3	
260	QC21-SA	12 Ea	12/1/17	0.00	0.00	QC21	

Part Op 100 - 1-Cut as per Dwg B67-43001 Dwg Rev: _____ Prog Rev: _____ ****grain direction 45 degree" **** 2-Debur if

Descriptions: necessary

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Bend as per Dwg B67-43001

140 - QC5- Inspect part completeness to step on W/O

150 - Weld per dwg A/R Aluminum rod Batch: _____ 1- Weld as per dwg B67-4300 2- Grind weld flush

170 - QC10- Inspect visual per QSI004- ground welds

180 - QC5- Inspect part completeness to step on W/O

190 - Chemical Conversion Coat per QSI005 4.1

200 - Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

210 - QC3- Inspect Part Finish

220 - SEND TO TALMAR FOR FOAM AND FABRIC

230 - Receive & Inspect for Damage & Mat'l Certs

240 - QC6- All purchased or subcontracted products

250 - Identify as per dwg & Stock Location: _____

260 - QC21- Final Inspection - Work Order Release

POB38005

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.032	24	64	0	0

Part Specifications

Specifications could not be found.

Plex 10/10/17 10:27 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

Work Order ID 160864

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160864

Page 1

Item ID: PB67-43001-73

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 20 Degree Cover Plate

Stop ***NS2***

Start Date: 5/5/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 12.00

12

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: **DAS**
21 Date: **MAY 05 2017**

Tooling:

Date:

Run Start ***NR1***QC: **9-89** Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-73	Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.82

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: CProg Rev: C

****grain direction 45 degree****

2-Deburr if necessary

1205/17/05/06

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.12

Quality Control

1205/17/05/06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER : ☐																							

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1 60864

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N900040100

Setup **Start** ***NS1***

Stop *NS2*

Start Date: 5/5/2017 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 5/26/2017 **Req'd Qty:** 12.00 ***12***

Customer:

Reference: SCHEDULED/U

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 160864

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Item ID: PB67-43001-73

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 20 Degree Cover Plate

Start Date: 5/5/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 12.00

12

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: _____ Large Fab M130855 Memo 1- Weld as per dwg B67-4300 2- Grind weld flush	0.00 2.04				<u>12x</u>	<u>2017-06-22</u>	<u>S-L</u> <u>CPC</u>	
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<u>12</u>	<u>17.07.05</u>		<u>DAS</u> <u>9</u> <u>9-89</u>
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.24				<u>12</u>	<u>17.07.05</u>		<u>DAS</u> <u>9</u> <u>9-89</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 160864

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Page 4

Item ID: PB67-43001-73

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 20 Degree Cover Plate

Start Date: 5/5/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 12.00

12

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00

190

HandFinish

Memo

0.34

Hand Finishing

12 ϕ 17-09-5. DAS 34 9-89

200

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

200

Powdercoat

Memo

0.73

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12 ϕ 17-09-5. DAS 34 9-89

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.12

Quality Control

12 SEP 06 2017 DAS 24 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Work Order ID 160864

Thursday, May 04, 2017 4:03:50 PM

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Page 5

Item ID: PB67-43001-73 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 20 Degree Cover Plate
Start Date: 5/5/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/26/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Purchasing Purchasing	PURCHASING Memo SEND TO TALMAR FOR FOAM AND FABRIC	0.00 0.00	P/O 37772			12	SEP 14 2017		DAS 13 9-89
230 *230* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.24				12 x SPN-10-30			
240 *240* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				12			DAS 38 9-89

NOV 08 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		☐ OTHER :							

Thursday, May 04, 2017 4:03:50 PM

1 60864

Page 6

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/5/2017 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 5/26/2017 **Req'd Qty:** 12.00 ***12***

Customer:

Reference: SCHEDULED/U

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250	Identify as per dwg & Stock Location:	0.00
-----	---------------------------------------	------

250

Packaging	Memo	0.12
-----------	------	------

Packaging

260	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

260

QC	Memo	1.20
----	------	------

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : ☐																																																																									

Picklist Print

Thursday, May 04, 2017 4:03:50 PM

Page 1

Work Order ID: 160864

160864

Parent Item: PB67-43001-73

PB67-43001-73

Parent Item Name: 20 Degree Cover Plate

Start Date: 5/5/2017

Required Date: 5/26/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:ec IPP rev B
10.09.30 per rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	143.9536	2.02	25.51579			

M6061T6S 0.32

6061-T6 Sheet 0.032"

17/05/16

Location

Loc Qty

Loc Code

MAT021

143.953563

m131352

4.020037

m135724

54.333526

m136942

85.6

27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

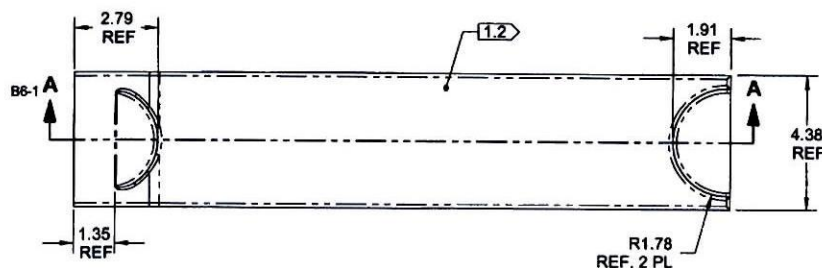
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

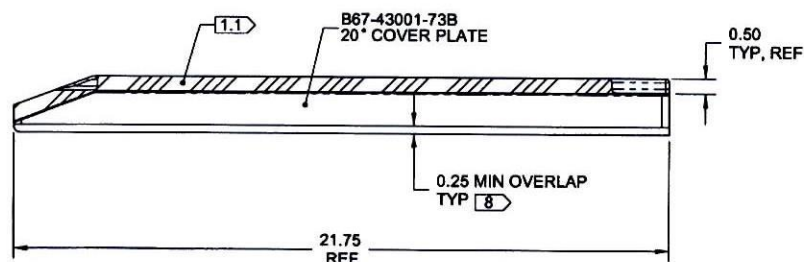
8 7 6 5 4 3 2 1

ITEM	QTY -73	P/N	DESCRIPTION
1	1	B67-43001-73	20° COVER PLATE
2	1	B67-43001-73B	20° COVER PLATE
3	A/R	1637-001	SEE NOTE 1.1
4	A/R	1495	SEE NOTE 1.2
5	A/R	LA4009	SEE NOTE 1.3

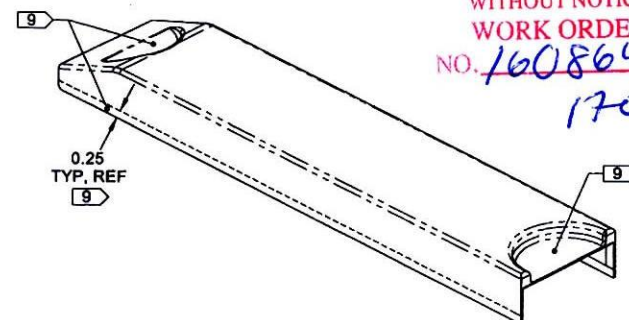
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160864 MJS
170505



B67-43001-73 COVER PLATE ASSEMBLY
(MAKE FROM B67-43001-73F)



SECTION A-A D8-1



RELEASED
2010-09-16
MM

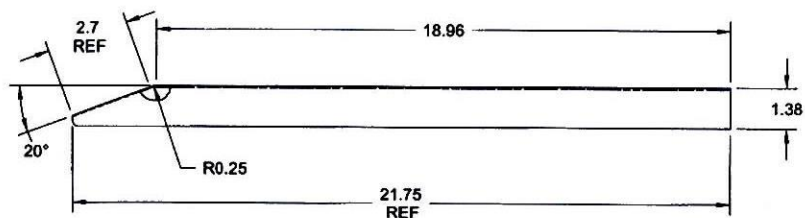
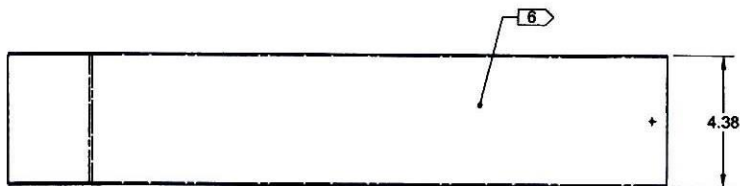
- NOTES:**
- MATERIAL:**
 - 1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED-CELL, FLAME RETARDANT, 0.50 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK REF. TULMAR P/N 1637-001
 - 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK REF. TULMAR P/N 1495
 - 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009
 - 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
 - 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.77 lbs REF
 - 8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE
 - 9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDES

TABLE 1 3

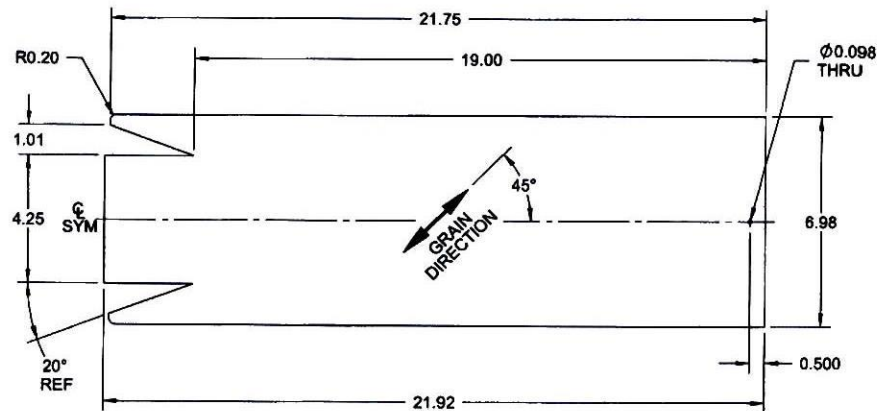
TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

C	REDRAWN PREMIER AVIATION DRAWING LAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC: 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 7 AND 26 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	10.04.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-73 TITLE 20° COVER PLATE REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

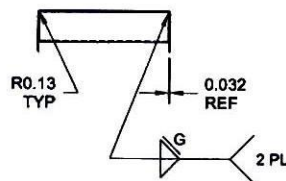
8 7 6 5 4 3 2 1



B67-43001-73B BENDING DETAIL
(MAKE FROM B67-43001-73F)



B67-43001-73F COVER PLATE FLAT PATTERN



RELEASED
2010-09-16
MPO

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027 OR ASTM B209
REF: DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-73B" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-73	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	20° COVER PLATE	NTS
DATE	10.04.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

61551 1

Ship Date
10/23/2017

Bill To:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To:

Dart Aerospace
1270 Aberdeen Street
Buyer: Chantal Lavoie
Tel: 613-632-5200
Hawkesbury, ON K6A 1K7
Canada

Order number	Sales order date	Account number	Loc	Account manager
35254	9/15/2017	CDART100	H	Francine Bigras
PO number	Ship via	Shipping Terms		
PO37772	Pick-Up	FOB HAWKESBURY		
Item No.	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order
Description				

8421-106
Plate, Cover 90°, Ass'y
Drawing No: B67-43001-69+MU
DWG Rev: D+1
Line 1
SF 43035
PICKUP BY CUSTOMER

Lot no.: BATCH0000000012 4.00

8421-105
Cover Plate, 20°
Drawing No: B67-43001-73+MU
DWG Rev: C+1
Line 2
SF 43036

Lot no.: BATCH0000000011 12.00

12.00

SPT 10-30

Certificate of Conformance

☒ See Certification Enclosed

I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 225.

Authorized Inspector

Suzanne LaLiberté

Date: OCT 23 2017



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038005

Supplier: TUL001-VC
Tulmar Safety Systems
1123 Cameron St
Hawkesbury
ON
K6A 2B8 Canada
Phone: 613 632 1282
Fax: 613 632 2030

PO No: PO038005
PO Date: 10/11/17
Due Date: 10/11/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lacelle, Linda
Phone: llacelle@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Prepay
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		PB67- 43001- 83	-	D-Pad Assembly, Short DWG REV D IPP rev A new issue 08.06.19 EC verified: DD IPP rev B 10.09.30 per rev C dwg EC verified by:DD		Firmed	10/11/17	16 Ea	0 Ea	16 Ea	\$55.00/Ea	\$880.00
2	160871	PB67- 43001- 69	-	90 Degree Cover Plate SEND TO TULMAR FOR FOAM AND FABRIC		Firmed	10/11/17	4 pcs	0 pcs	4 pcs	\$162.00/pcs	\$648.00
3	160864	PB67- 43001- 73	-	20 Degree Cover Plate SEND TO TALMAR FOR FOAM AND FABRIC		Firmed	10/11/17	12 pcs	0 pcs	12 pcs	\$165.00/pcs	\$1,980.00

Grand Total: \$3,508.00

Order Notes

DWG REV D IPP rev A new issue 08.06.19 EC verified: DD IPP rev B 10.09.30 per rev C dwg EC verified by:DD

DWG REV D IPP Rev:A 08-06-20 new issue DD verified by:ec IPP Rev B 10.10.04 per revD dwg EC verified by:DD

DWG REV C IPP Rev:A 08-06-19 new issue DD verified by:ec IPP rev B 10.09.30 per rev C dwg EC verified by:DD

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance
A041 quality management system



J. ENNIS FABRICS

CERTIFICATE OF COMFORMANCE

January 21, 2016

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawesbury, Ontario
K6A 2B8

Attention: Allan Chalot
E-Mail: allan@tulmar.com

Customer Purchase Order Number: 29645-00
J. Ennis Fabrics Reference Number: 03406993 T1

The following item/s is supplied under the stated reference:

- Oxford 7
- Description: oxford 7 Black
- Backing Content: 100% Polyurethane
- Coating: Product has a Polyurethane
- Construction: 0420 Denier
- Content: 100% Nylon
- Description: High Density Nylon, Piece Dyed, PU coated
- Features: Phthalate Free
- Weight: 5.98 ounces per square yard. 8.98 Ounces per Linear yard
- Width: 58"(147 cm)
- Hydrostatic Resistant: AATCC 127(Suter)-Average 800 mm
- Protective Finish: DWR Durable Water Repellant

This is to certify that the product/s stated herein have been manufactured in accordance to the specifications stated by the manufacturer as well as the specifications stated on your order

Sincerely;

JAN 29 2016

J. Nykolyshtyn
Jennifer Nykolyshtyn
Customer Service Center



1495
B#34

cle's used to mfg.

B67-43001-73+H U

Genevieve Laliberte
Oct. 23/17



Oxford 58"

OXFOR7 SPECIFICATIONS

Description	Oxford 7 Black
Backing Content	100% Polyurethane
Cautions	Product will fade with prolonged U.V. exposure. Not dimensionally stable with temperature change. Nylon is NOT suitable for boat tops, travel covers, tonneau covers or other outdoor applications.
Cleaning Instruction	Mild Soap and Water.
Coating	Product has a Polyurethane Coating.
Construction	0420 Denier
Content	100% Nylon
Description	High Density Nylon, Piece Dyed, PU coated
Features	Phthalate Free
Hydrostatic Resistan	AATCC 127 (Suter) - Average 800 mm.
Protective Finish	DWR Durable Water Repellant
Roll Size	50 yards (45.7 m)
Style	Solids / Plain
Uses	Apparel Equine Products Hockey Equipment
Weight	5.98 ounces per square yard. 8.98 Ounces per Linear Yard
Width	58" (147 cm)

** This information is offered for your general guidance only. It is accurate to the best of our knowledge and is not intended to relieve the user from its responsibility to investigate and understand other pertinent sources of information and to comply with all laws and procedures applicable to the safe handling and use of this material. Final determination of the suitability of any product for an application rests with the user.

*This term and any corresponding data refer to typical performance in the specific tests indicated and should not be construed to imply the behavior of this or any other material under actual fire conditions.

Although we do our best to make sure that the colors on our web site are accurate, actual colors will vary. Subtle color differences and textures may not be fully appreciated on some systems due to differences in monitors and/or printers.

www.jennisfabrics.com
 Email: support@jennisfabrics.com

21/Jan/2016

English : (800)663-6647
 French : (888)663-6647
 USA : (877)953-6647
 Fax : (888)274-2910

TULMAR**Certificate of Conformance**

Tulmar P/N 1637-001	Description 1/2" X 42" X 72"	Dwg #	Revision	Qty 4
Tulmar PO # 30168-00	Line Item # 01	Supplier Name / Address AM RUBBER & FOAM GASKETS INC 2074 STEELES AVE EAST, UNITS 1 & 2 BRAMPTON, ON L6T 4Z9		Supplier Packing Slip # 16428

Supplier Declarations:

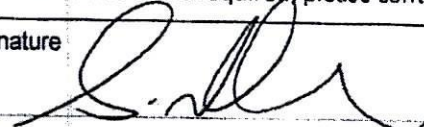
Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

FOAM, SBR/EPDM/CR BLEND, BLACK
ASTM D1056 2A2, 1/2"TH.
SHEET SIZE 42" X 72" +/-0.5"
BRITTLINESS TEMP OF -40 DEGREES F
IAW ASTM D746, FMVSS 302.
QUALITY CLAUSE: GrBT3

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name SANDRA PULSINELLI	Date (DD-MMM-YYYY) 07-06-2016
Title PRODUCTION	Email sandra@amrubber.ca	Phone # 905-455-1449

1637-001**3#9****JUN 16 2016**

Form Revision 13 Aug 2012





48 Burgess Place
Wayne, NJ 07470

Certificate Of Analysis

3/29/2017

Sales Order Number: 9656
Customer Order Number: 31110

Manufactured for
TULMAR SAFETY SYSTEMS

14556-S1.9 CAT7020, P/N 7153-002 14556-S1.9 - CAT7020 QUART CANS SQUARE UNLINED

Lot# PNJ-0217-0325 Qty: 11 EA Manufacture Date: 3/20/17 Expiration Date: 9/20/17

Test(s)	Results	Min	Max
	NOT APPLICABLE	NA	NA

4914-C7 DB7020M1, P/N 7153-001 14914-C7 - DB7020M1, GALLON LINED CAN

Lot# PNJ-0217-0328 Qty: 58 EA Manufacture Date: 3/3/17 Expiration Date: 9/3/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	23.4000	21.00	24.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	810.0000	450.00	1,250.00	Centipoise

4931-C6.9 LA4009NOVOC, P/N 7122-001 14931-C6.9 - LA4009NOVOC, GALLON CAN

Lot# PNJ-0317-0159 Qty: 54 Gallon Cans + Part Can @ 5# Manufacture Date: 3/9/17 Expiration Date: 3/9/18

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	13.5000	11.50	13.50	Percent
Brookfield,RVT,#4 Spindle,20RPM,78F	800.0000	700.00	1,300.00	Centipoise
Visual check for dry film color	pass	(CLEAR TO SL. HAZY) PASS/FAIL		

"The material supplied conforms to all applicable engineering drawing, specifications and PO requirements."

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Country of Origin: USA

7122-001
B #11

APR 05 2017



DART
AEROSPACE
S004031



20 Degree Cover Plate

PART NO:
Revision:
Operation:
Change No:

PB67-43001-73

Packaging

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 10/31/17
Job No: 160864

Work Order Summary

Friday, October 06, 2017 8:26:46 AM

Page 1 of 2

Criteria : Work Order ID: 160864 Item ID: PB67-43001-73 Product Family SMALL FAB
Work Order Start Dates 5/5/2017 to 5/5/2017 11:59:59 PM Work Order Required Dates 5/26/2017 to 5/26/2017 11:59:59 PM
Reference: SCHEDULED/U
Work Order Status Released

Work Order ID	160864	Required Qty	12.0000	Status Code	Released
Item ID	PB67-43001-73	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	20 Degree Cover Plate				
Current Acct Value	\$208.011				

Start Date	5/5/2017	Required Date	5/26/2017	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$41.610	\$0.000	\$2.898	\$2.898	100.00%
Labor	\$102.507	\$0.000	\$19.809	\$19.809	100.00%
Outplant	\$0.000	\$0.000	\$122.976	\$122.976	100.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$218.155	\$0.000	\$62.329	\$62.329	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$362.272	\$0.000	\$208.011	\$208.011	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M6061T6S.032					
6061-T6 Sheet 0.032"	25.5158		5/6/2017	27.0000	\$41.610
				Total Matl Amts:	\$41.610

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01												
5/8/2017												
130			0.17	0.17	1.00	1.00	1.00	\$3.584	\$21.500	\$50.915	\$0.000	\$75.999
130			0.17	0.17	0.00	0.00	1.00	\$3.584	\$0.000	\$7.275	\$0.000	\$10.859
5/9/2017												
130			0.17	0.17	0.25	0.25	1.00	\$3.584	\$5.375	\$18.185	\$0.000	\$27.144
Total:			0.50	0.50	1.25	1.25	3.00	\$10.752	\$26.875	\$76.374	\$0.000	\$114.001

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ROQU01												
9/5/2017												

Friday, October 06, 2017 8:26:46 AM

Work Order Summary

Page 1 of 2

190			0.00	0.00	0.45	0.15	3.00	\$0.000	\$3.266	\$8.152	\$0.000	\$11.417
Total:			0.00	0.00	0.45	0.15	3.00	\$0.000	\$3.266	\$8.152	\$0.000	\$11.417

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
lu01												
	6/22/2017											
150			0.00	0.00	1.97	1.97	1.00	\$0.000	\$42.450	\$86.163	\$0.000	\$128.612
	7/4/2017											
150			0.00	0.00	0.22	0.22	1.00	\$0.000	\$4.640	\$9.418	\$0.000	\$14.057
Total:			0.00	0.00	2.19	2.19	2.00	\$0.000	\$47.089	\$95.580	\$0.000	\$142.670

Work Center Powdercoat

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ROQU01												
	9/5/2017											
200			0.00	0.00	0.21	0.21	1.00	\$0.000	\$4.550	\$11.356	\$0.000	\$15.906
Total:			0.00	0.00	0.21	0.21	1.00	\$0.000	\$4.550	\$11.356	\$0.000	\$15.906

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
conw01												
	5/6/2017											
100			0.00	0.00	0.48	0.48	1.00	\$0.000	\$9.975	\$26.693	\$0.000	\$36.668
Total:			0.00	0.00	0.48	0.48	1.00	\$0.000	\$9.975	\$26.693	\$0.000	\$36.668